

Work Order ID 62658

Wednesday, October 06, 2010 3:59:44 PM

Page 1

Item ID: D2274

Accept

Revision ID:

Item Name: Radius Block

Setup Start

Stop

Start Date: 10/6/2010 Start Qty: 300.00

Required Date: 10/15/2010 Req'd Qty: 300.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-07

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00



SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

SL 10/10/26

315

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

SL 10/10/26

315

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/10/26

315

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

J.A 10/10/26

315

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Tumble ☐ Deburr any rough edges after tumbling

1310-10-29

315

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=) 10/11/01

315

W/O:		WORK ORDER CHANGES					
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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

315. ~~10/10/1~~

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

10/11/1 5/315

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/02 MF
10-11-01

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Picklist Print

Wednesday, October 06, 2010 3:59:48 PM

Page 1

Work Order ID: 62658



Parent Item: D2274



Parent Item Name: Radius Block

Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP H 00.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	83.8743	0.0916	28.92632			



6061-T6 Bar .750 x .125



SL 10/10/26

Location

Loc Qty

Loc Code

MAT01

83.8743

113608

79.6

113680

1.4947

113719

2.7796

- 29.75

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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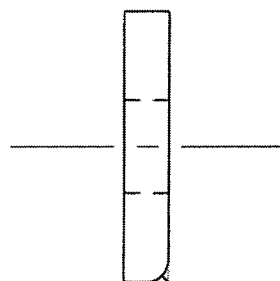
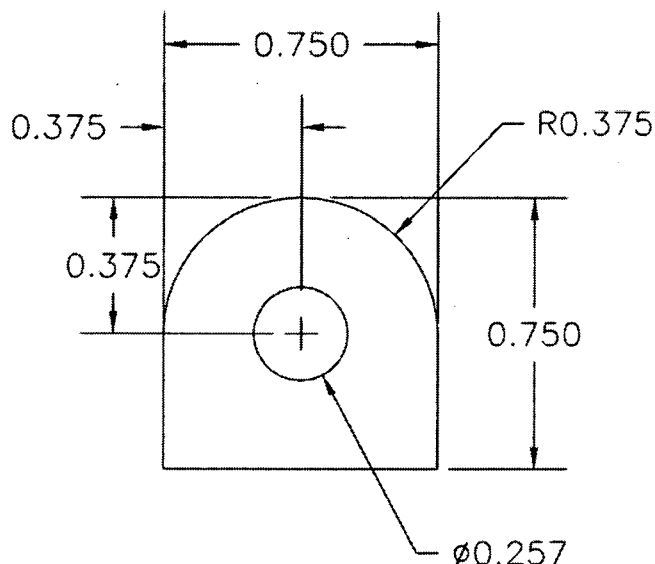
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO VENDOR
WITHIN 1000
WORK ORDER
NO. *62458*



00.05.16
00.05.16
0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

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